

Work Order ID 116619

Tuesday, April 22, 2014 12:54:06 PM

116619

Page 1

Item ID: D2445 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Door 350
Start Date: 4/23/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: AA Date: 14-4-22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2445	Rev D								

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 23899

Description: D2445 Baggage Door

Supplier: Delastek

Certification of Conformity and process sheet from Delastek is required.

OK 14/04/23 1

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

P44/17 (1)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 116619

Tuesday, April 22, 2014 12:54:06 PM

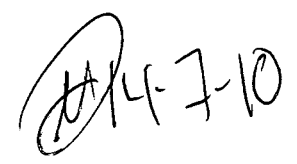
116619

Page 2

Item ID: D2445 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Aft Door 350
Start Date: 4/23/14 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 5/02/14 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC6- Inspect dimensions to drawing	0.00				1			
130									
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Identify as per dwg & Stock Location: <u>ST224</u>	0.00				1			
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

ML5 14-07-10


DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Transport									
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Tuesday, April 22, 2014 12:54:18 PM

Page 1

Work Order ID: 116619

116619

Parent Item: D2445

D2445

Parent Item Name: Aft Door 350

Start Date: 4/23/14

Required Date: 5/02/14

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP REV:A 12.03.14 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P		Purchased	No			120	Each	0.0000	1	1			

D2445P

Aft Door Assembly

14/4/14 

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13

CUT 2 PLACES AS PER DETAIL A ON PAGE 2
OR USE D2621 AS TEMPLATE

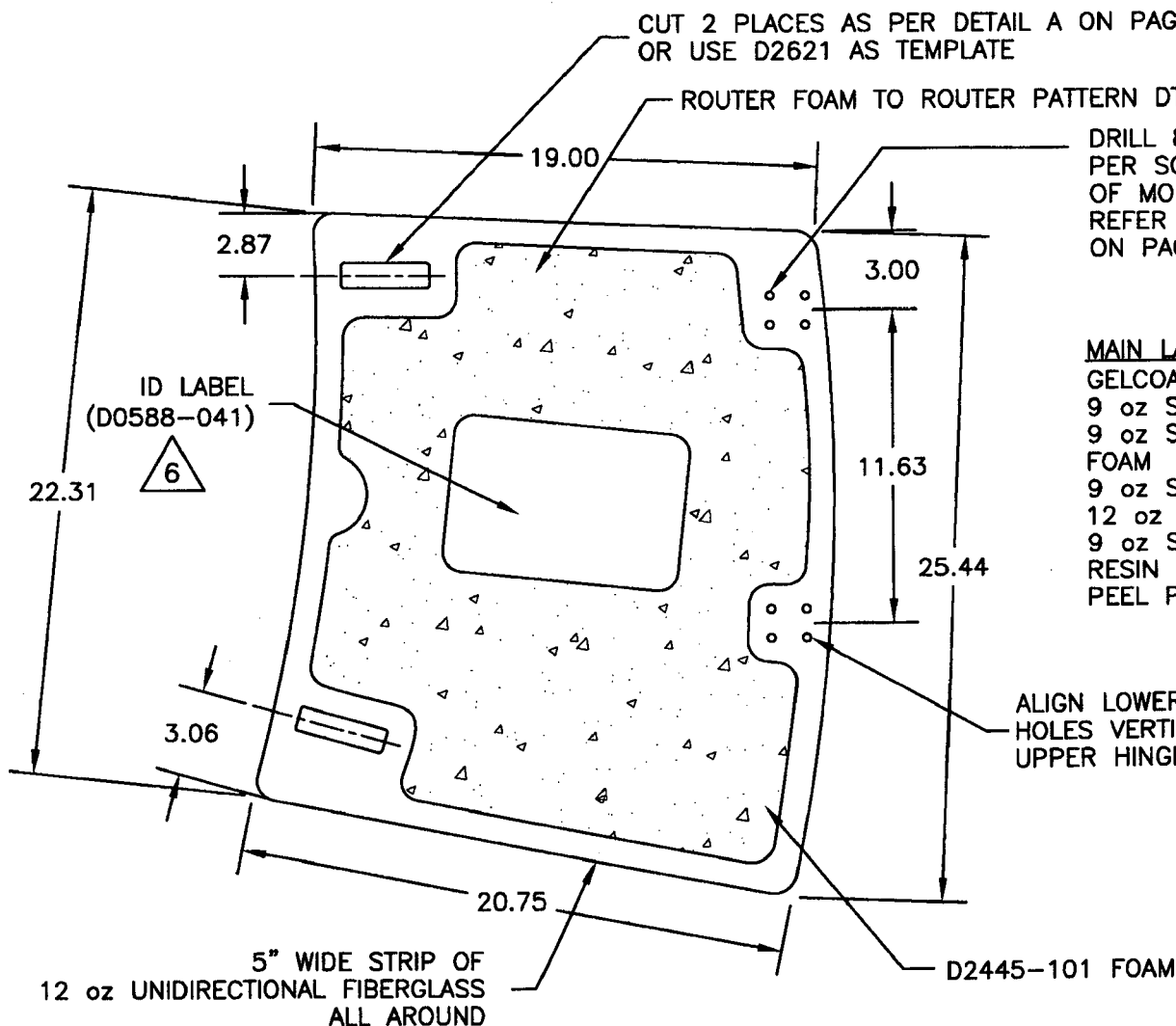
ROUTER FOAM TO ROUTER PATTERN DT8035

DRILL 8 HOLES $\varnothing 0.171$
PER SCRIBE LINES
OF MOLD DT8036 OR
REFER TO DETAIL B
ON PAGE 2

MAIN LAYUP

GELCOAT #GEL 944W005
9 oz SATIN
9 oz SATIN
FOAM
9 oz SATIN
12 oz UNIDIRECTIONAL
9 oz SATIN
RESIN
PEEL PLY

ALIGN LOWER HINGE
HOLES VERTICALLY WITH
UPPER HINGE HOLES

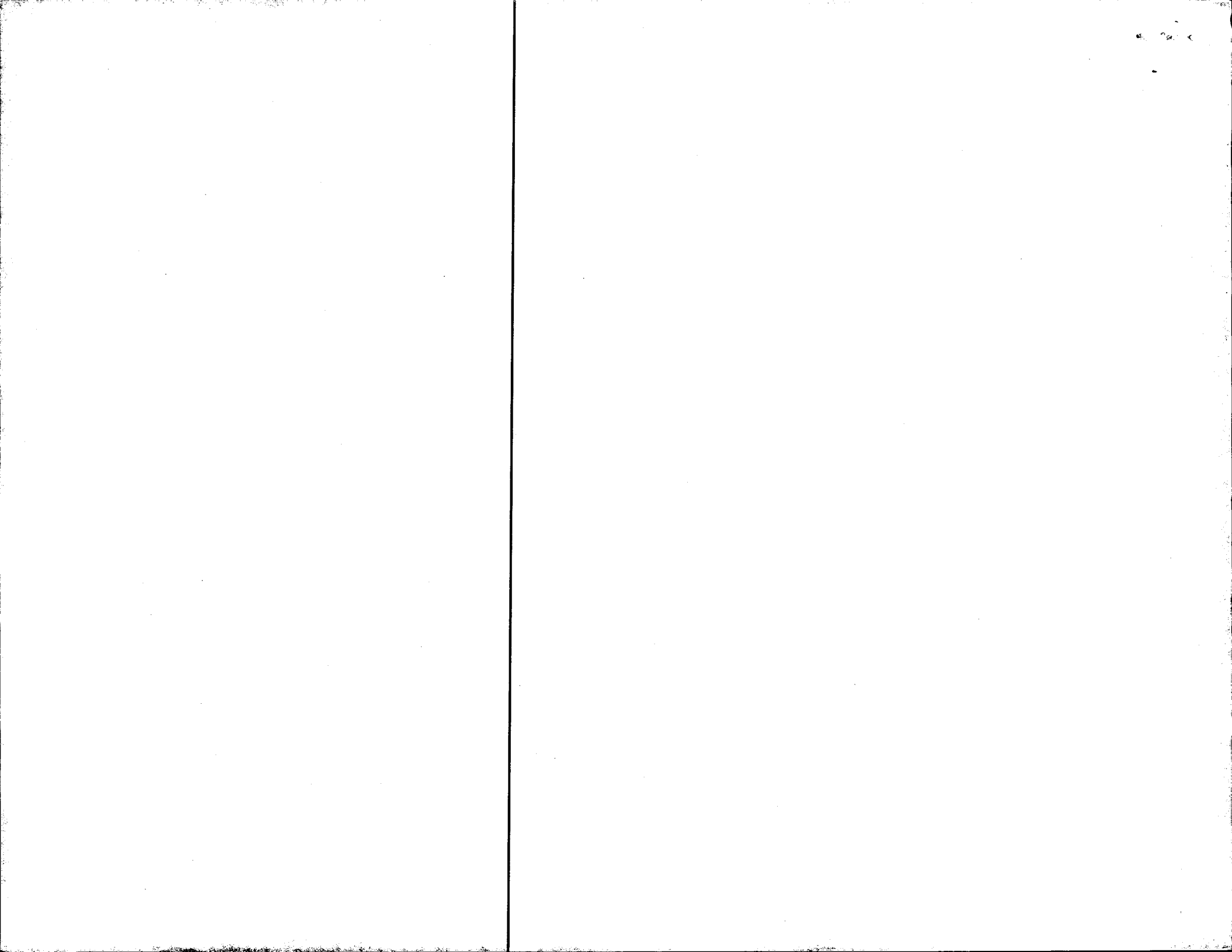
**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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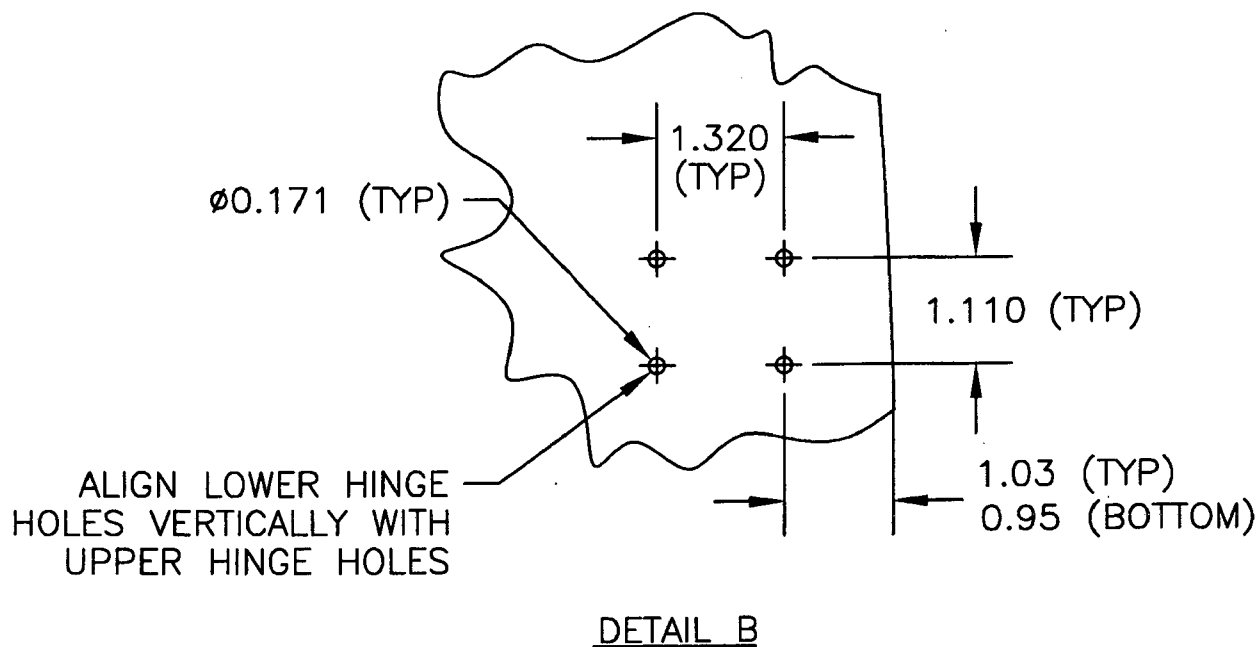
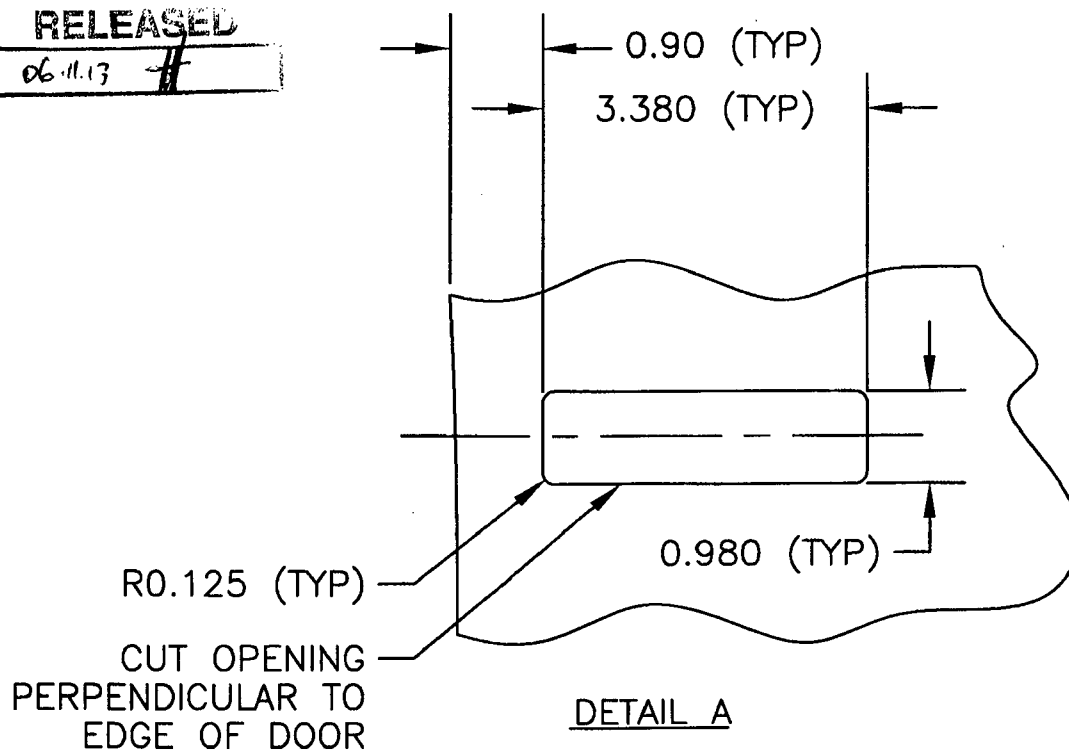
11661a ND
14-4-22





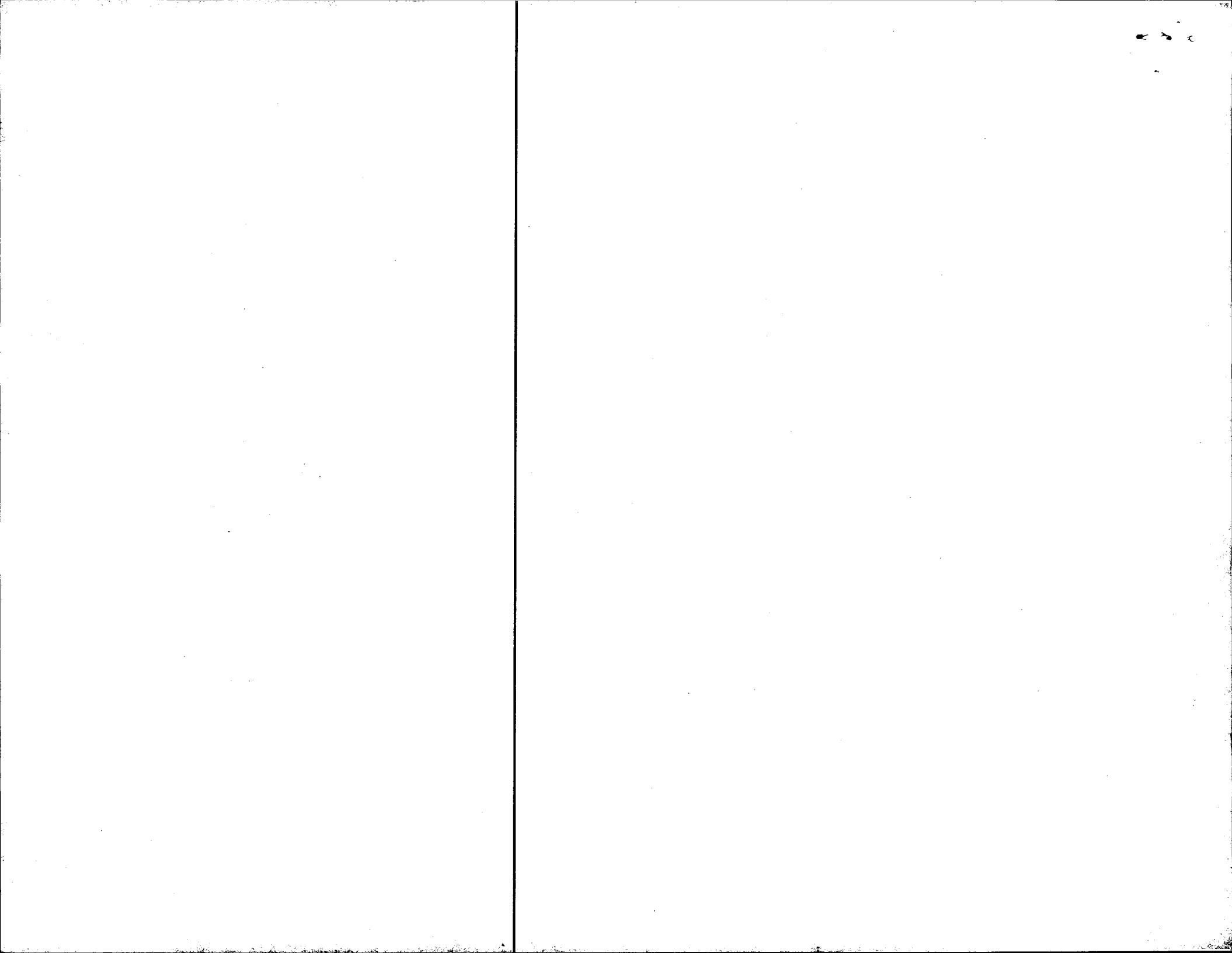
DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO23899**

Purchase Order Date 4/23/2014

PO Print Date 4/23/2014

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
Cal 4/24/14

Contact Name
Vendor Phone 819 533 5788

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2445P AS PER DWG D2445 REV. D B116620	Aft Door Assembly	6/24/2014 Yes 6/24/2014		1.00 Each	\$592.76	\$592.76
Line Total:							\$592.76
2	D2445P AS PER DWG D2445 REV. D B116619	Aft Door Assembly	6/24/2014 Yes 6/24/2014		1.00 Each	\$592.76	\$592.76
Line Total:							\$592.76

Note:

4/23/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57576
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
16-06-2014	23-04-2014	24570	Chantal Lavoie	PO23899	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Jocelyne Laurin, 221			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line 1 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque B116620 Drawing N° : D2445 Rév.: D Serial # B116620 Lot # 61317	
1	0	1	DKC134-0013	Line 2 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque B116619 Drawing N° : D2445 Rév.: D Serial # B116619 Lot # 61858	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

DELASTEK
53

Client	: DART US DART AEROSPACE	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 61317	Numéro Article	: DKC134-0013
Numéro	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-04-30 No. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Dûe	: 2014-06-30
Job précédente	: 61316	Qté:	1 Ud UNITE

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Client: N/A



E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur plusieurs séquences, numéro du moule passe de DT-8036 pour DKO-0235, numéro du moule passe de DT-8619 pour DKO-0063, ajouter IF134-0006 pour le taillage

Formulaire d'inspection: N/A

COPIE

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment	Qty.: 0.200 UNITE(s)/Unit	Total : 0.200 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 20/05/14 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment	Qty.: 0.200 KILOGRAMME(s)/Unit	Total : 0.200 KILOGRAMME(s)
	Gel Coat Blanc N° Gel 944W005	N° de Lot: 1-43003-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment	Qty.: 0.0320 GALLON(s)/Unit	Total : 0.0320 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: 1-27829-1

Date: Mercredi, 2014-04-30 08:13:28

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61317

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

5.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine

Date: 20/05/14 Sceau:



6.0

GEL COAT

Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IF134-0007

Date: 20/05/14 Sceau:



7.0

AAC1885

Tissu à délaminer Release ply B

Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

8.0

AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

9.0

AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0

AC0943

Stretchlon 200 poche à vide Vert

Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

12.0

AMB0511

N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)
N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

13.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Découper les tissus selon IF134-0007.

Information de référence pour les tissus::

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61317

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

4 plis de tissus de 9.7 oz.
1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.
3 fois le sac à vide Strechlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Date: 29-04/14 Sceau:



15.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45606-1

17.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°
DDM-9 par quantité de résine N° 411-350.

Date: 20/05/14 Sceau:



18.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Laminer la pièce selon IF134-0007.

Date: 20/05/14 Sceau:



19.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 11:15 Heure Curing Fin: 8:00











Date: 20/05/14 Sceau:



Date: Mercredi, 2014-04-30 08:13:28

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61317		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>			
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>9-05-14</u> Sceau: 			
23.0	AAC1611	Polybond B46F	
Comment Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>			
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)	
Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>61319</u>			
25.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Coller le Foamcore selon IF134-0007. Date: <u>21-05-14</u> Sceau: 			
26.0	BAGGING	Faire le bagging sur la pièce	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>8:15</u> Heure Fin Curing: <u>9:30</u> Date: <u>21-05-14</u> sceau: 			

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61317

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45606-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst
N° DDM-9 par quantité de résine N° 411-350.

Date: 22/05/14 Sceau:



30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus de verre selon IF134-0007.

Date: 22/05/14 Sceau:



31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 9:00 Heure Curing Fin: 8:00

Date: 22/05/14 Sceau:



32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & rebords.

Date: 23/05/14 Sceau:



Date: Mercredi, 2014-04-30 08:13:28

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61317

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler la pièce selon IF134-0006.

Date: 23/05/14 Sceau:

34.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-45373-1

35.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 23/05/14 Sceau:

36.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-54556-3

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-44895-1

38.0

PRIMER

Application primer



28/05/14



Fiche: 6607



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer batisseur selon I.G. 0008

Date: 26/05/14 Sceau: # de fiche de mélange: 6605

Refuse 27 mai 2014
La reprendre
le batisseur I.G. 0008



39.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-45373-1

40.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 28/05/14 Sceau:

02-06-14



Date: Mercredi, 2014-04-30 08:13:29

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61317

Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0588-041 N° de Lot: _____

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)
Surface Veil N° de Lot: _____

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: _____

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: _____

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: _____ Sceau: _____

46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1545563

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase


Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 40909-1

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer final selon I.G. 0008


Date: 02-06-14 Sceau:  # de fiche de mélange: 6611

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 4 juin 14 Sceau: 

N/A
le client ne veut pas sur ces pièces
2/6/14

Date: Mercredi, 2014-04-30 08:13:29

Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61317

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date:

4 juin 14

Sceau:



B11620